

83045

Page 1

N900040100

```

Setup  Start  *NS1*
      Stop   *NS2*

```

Start Date: 12/04/2012	Start Qty: 12.00	*12*
Required Date: 26/04/2012	Req'd Qty: 12.00	*12*

Cust Item ID:
Customer:

Reference:

Approvals: Process Plan: MLJ Date: 12/04/12 Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run	Start	*NR1*
	Stop	*NR2*

[illegible]

W/O: 83045		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D3270-041 PAR #: _____ Fault Category: hard FAD. NCR: Yes No DQA: AK Date: 12/11/02
 Resolution: Scrap Disposition: Scrap QA: N/C Closed: CK Date: 2/11/05

NCR: 12-2002		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
12/10/02	# 110	Qtr 1 part scrap due to welding caused the tubing to be pugged. caused the hole in the tube to be smaller w/ch. with time for the tube to pass through. RC improve welding process.	(DAS 16 2-02) ASZ 2012	Scrap + destroy 1 qtr 1 part and replace D3270-1 B 72362 D3270-3 B M112632 x1	12/10/22		(DAS 16 2-02) QSF 2012	(DAS 16 2-02) 12/10/22
			12/10/22	A/c 122588 122358	12/10/22	12/10/22		

10.29
10.29

NOTE: Date & initial all entries

Work Order ID 83045

April-12-12 1:02:09 PM

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Item ID: D3270-041
Revision ID:
Item Name: Fuel Scupper Assembly

Accept

N900040100

Setup Start ***NS1***
Stop ***NS2***

Start Date: 12/04/2012 Start Qty: 12.00 ***12***
Required Date: 26/04/2012 Req'd Qty: 12.00 ***12***

Cust Item ID:
Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start ***NR1***
Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

130 QC5- Inspect part completeness to step on W/O

0.00

130

QC

Memo

0.00

Quality Control

DAS 16 17/10/22

42

140 Chemical Conversion Coat per QSI005 4.1

0.00

140

HandFinish

Memo

0.00

Hand Finishing

12 12 12-10-23

150 White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00

150

Powdercoat

Memo

0.00

Powder Coating

START Time:

OVEN TEMPERATURE:

FINISH TIME:

3-40 3200 F

12x 12/10/24

m122878

4-10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 83045

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Item ID: D3270-041

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Item Name: Fuel Scupper Assembly

Stop ***NS2***

Start Date: 12/04/2012 Start Qty: 12.00

12

Cust Item ID:

Required Date: 26/04/2012 Req'd Qty: 12.00

12

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160	QC3- Inspect Part Finish	0.00							
160									
QC	Memo	0.00							
Quality Control									
165	Identify as per dwg & Stock Location	0.00							
165									
Packaging	Memo	0.00							
Packaging									
170	QC21- Final Inspection - Work Order Release	0.00							
170									
QC	Memo	0.00							
Quality Control									

12/10/30

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

April-12-12 1:02:13 PM

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Work Order ID: 83045

83045

Parent Item: D3270-041

D3270-041

Parent Item Name: Fuel Scupper Assembly

Start Date: 12/04/2012

Required Date: 26/04/2012

Start Qty: 12.00

Required Qty: 12.00

Comments: IPP Rev:A New Issue 05-11-01 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D3270-1		Manufactured	No			100	Each	61.0000	1	12			
---------	--	--------------	----	--	--	-----	------	---------	---	----	--	--	--

D3270-1

Mounting Base

Location

Loc Qty

Loc Code

WA022

61

24076

43

72362

18

M6061T6T0.375W.035

Purchased

No

100

f

163.2082

0.6666

8.420211

M6061T6T0 375W 035

6061-T6 RD Tube .375 x.035W

Location

Loc Qty

Loc Code

MAT014

163.2082

112652

163.2082

**

12.10.18

**

12.10.18

12

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

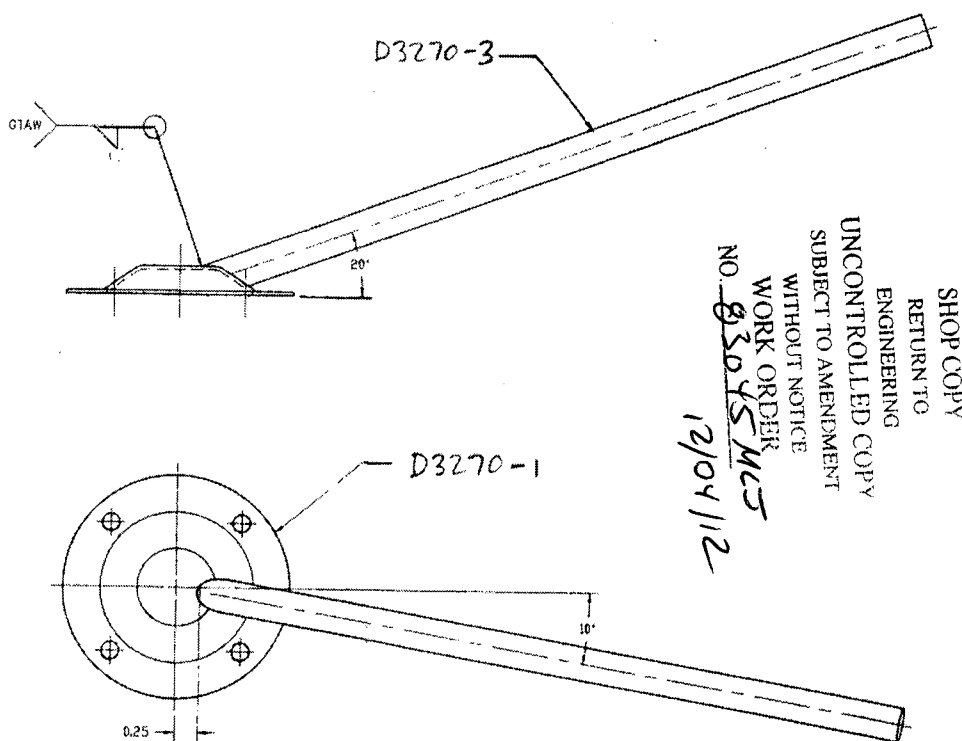
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DESIGN #	DRAWN BY #	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED CP	APPROVED #	DRAWING NO. D3270	REV. B SHEET 1 OF 2
DATE 05.07.14		TITLE FUEL SCUPPER DRAIN ASSEMBLY	SCALE NTS
A	04.02.20	NEW ISSUE	
B	05.07.14	ADD D3270-1 FLAT PATTERN	

RELEASED
04.02.23



D3270-041 FUEL SCUPPER ASSEMBLY

- NOTES:
- 1) WELD PER DART QSI 004 USING 5356 FILLER ROD.
 - 2) FINISH: CHEMICAL CONVERSION COAT PER QSI 005 4.1
POWDER COAT GLOSS WHITE (REF. 4.3.5.1) PER QSI 005 4.3
 - 3) ALL DIMENSIONS ARE IN INCHES
 - 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
 - 5) CONTOUR MAY BE ALTERED TO DOMED SHAPE AT FABRICATOR'S DISCRETION

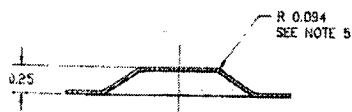
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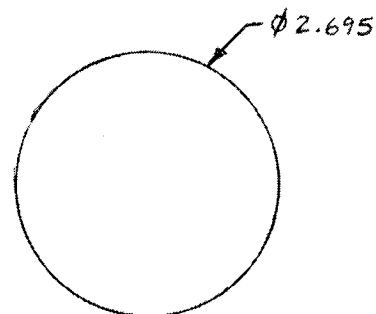
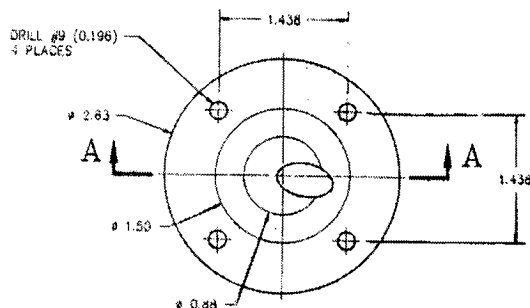


DESIGN	<i>#</i>	DRAWN BY	<i>#</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED	<i>CP</i>	APPROVED	<i>#</i>	DRAWING NO. <i>D3270</i>
DATE	05.07.14	TITLE	FUEL SCUPPER ASSEMBLY	REV. B SHEET 2 OF 2 SCALE NTS
A	04.02.20	NEW ISSUE		
B	04.02.20 05.07.14	ADD D3270-1 FLAT PATTERN		

RELEASED
04.02.23 *#*



SECTION A-A

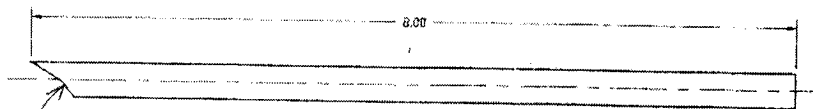


D3270-1 FLAT PATTERN

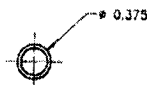


D3270-1 MOUNTING BASE

MATERIAL: 6061-T6 ALUMINUM SHEET 0.040" THICK PER QQ-A-250/11 (M6061T6S.040)



CONTOUR TO FIT
D3270-1



D3270-3 FUEL OUTLET TUBE

MATERIAL: 6061-T6 ALUMINUM TUBING 0.375" OD X 0.035" WALL (SEAMLESS)
PER MW-T-700/6 OR QQ-A-200/8 OR QQ-A-225/8
(M6061T6T0.375W.035)

03045

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